

Date: Wednesday, 22/10/2008 4:07:57 PM
User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : SEAT SUPPORT ASSEMBLY, RH
Job Number : 42866	
Estimate Number : 13329	
P.O. Number :	Part Number : D3784044
This Issue : 22/10/2008 S.O. No. :	Drawing Number : D3784 REV B
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 42522	Material :
Written By :	Due Date : 29/10/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JUD 08-10-22</u>	
Comment : Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

2.0	D3763044	End Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
End Fitting Assembly, RH
batch: B42955

FF 09/02/10

3.0	D37701	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Tube
batch: B42962

FF 09/02/10

4.0	D37703	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Tube
batch: B42963

FF 09/02/10

5.0	D3763041	End Fitting Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
End Fitting Assembly
batch: B42950 x 2 / B42951 x 2

FF 09/02/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 4:07:57 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: SEAT SUPPORT ASSEMBLY, RH

Job Number: 42866

Part Number: D3784044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	MS21042L3	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M109798

FF 09/02/10

(2)

7.0	AN960JD10L	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: M109632

(or NAS1149D0332J) batch: _____

FF 09/02/10

(2)

8.0	AN52510R20	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M109752

FF 09/02/10

(2)

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3784

****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented down****

****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented forward****

FF 09/02/10

(2)

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/02/10 (42 RH)

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and stock

Location: ST 257

JS 09/02/11 (42)

12.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

MF 09-02-12

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

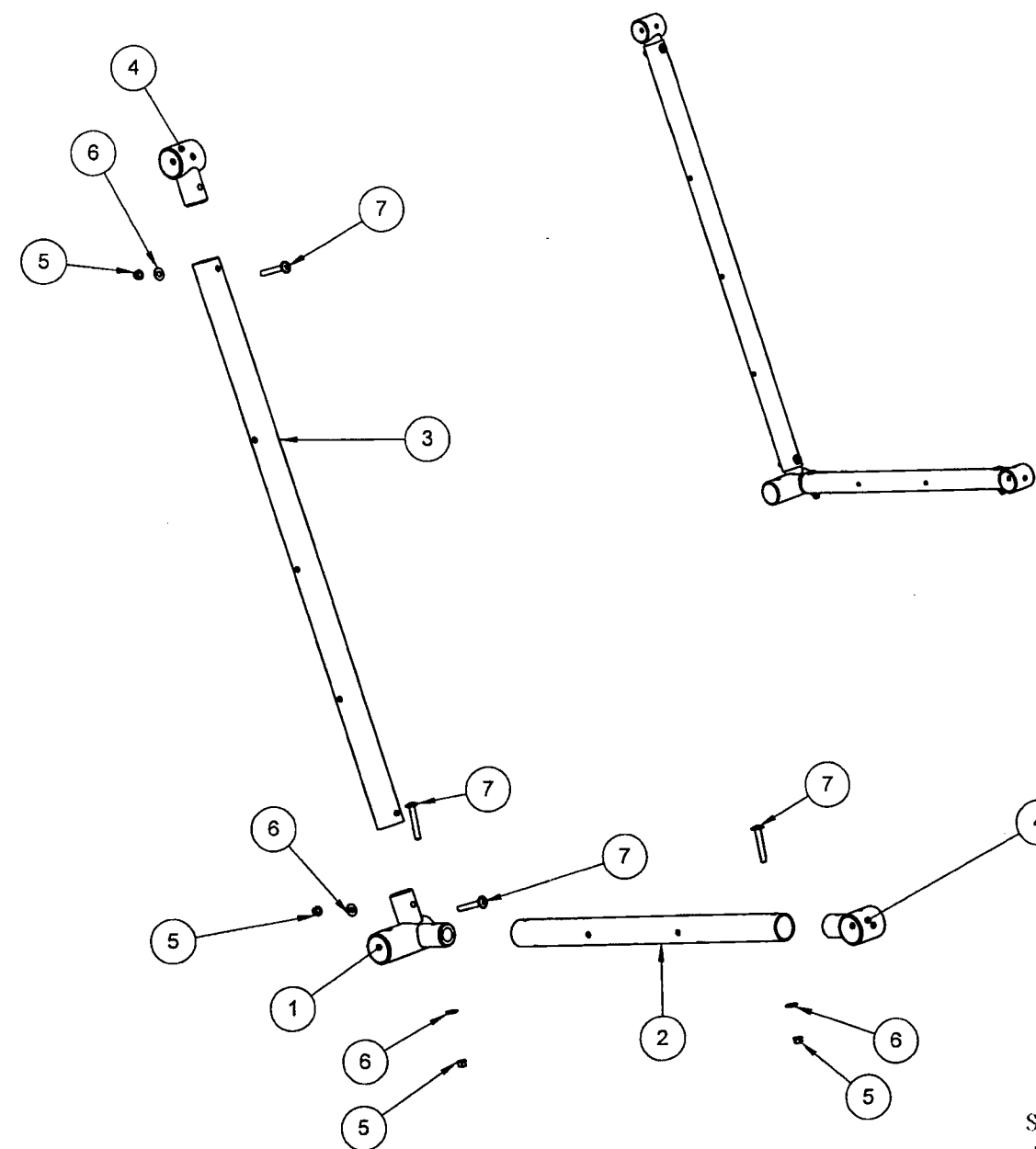
C

B

A

B
B
B

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4



D3784-044 SEAT SUPPORT ASSY, RH

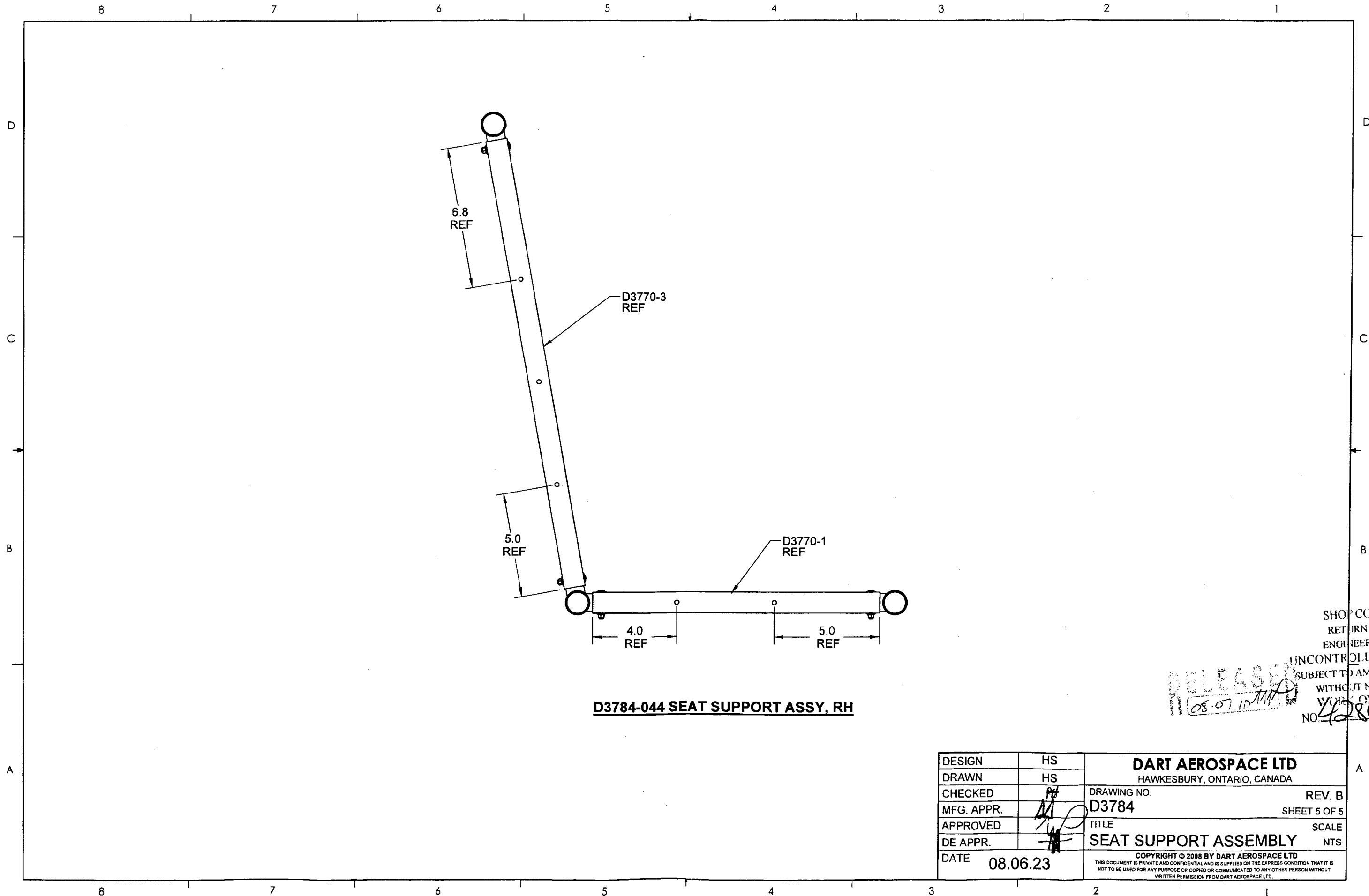
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

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NO. 42860

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



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DRAWN	HS		
CHECKED	HS	DRAWING NO. D3784	REV. B
MFG. APPR.	HS	SHEET 5 OF 5	
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